

Work Order ID 124334

September-11-14 12:02:33 PM

124334

Page 1

Item ID: D3639-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 9/10/14

Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 9/10/14

Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|-------|
| D3639 | Rev A |
|-------|-------|

| | | | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|
| 100 | | 0.00 | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-------|----------------|--|--|--|--|--|--|--|--|
| *100* | FLOW WATER JET | | | | | | | | |
|-------|----------------|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|----------|------|------|--|--|--|--|--|--|--|
| Waterjet | Memo | 0.00 | | | | | | | |
|----------|------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-------------------|------------------------|--|--|--|--|--|--|--|--|
| FLOW CNC Waterjet | 1-Cut as per Dwg D3639 | | | | | | | | |
|-------------------|------------------------|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|--|------------|--|--|--|--|--|--|--|--|
| | Dwg Rev: A | | | | | | | | |
|--|------------|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|--|-------------|--|--|--|--|--|--|--|--|
| | Prog Rev: A | | | | | | | | |
|--|-------------|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|--|-----------------------|--|--|--|--|--|--|--|--|
| | 2-Deburr if necessary | | | | | | | | |
|--|-----------------------|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-------|------|------|--|--|--|--|--|--|--|
| *110* | Memo | 0.00 | | | | | | | |
|-------|------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|----|--|--|--|--|--|--|--|--|--|
| QC | | | | | | | | | |
|----|--|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----------------|--|--|--|--|--|--|--|--|--|
| Quality Control | | | | | | | | | |
|-----------------|--|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-------|------|------|--|--|--|--|--|--|--|
| *120* | Memo | 0.00 | | | | | | | |
|-------|------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|----|--|--|--|--|--|--|--|--|--|
| QC | | | | | | | | | |
|----|--|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----------------|--|--|--|--|--|--|--|--|--|
| Quality Control | | | | | | | | | |
|-----------------|--|--|--|--|--|--|--|--|--|

DAS
38
9-89

OCT 20 2014

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

| Work Order: _____ | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|---|--|---|---|--------------------------------------|--------------------|-------------|--------------|--------------|
| Part No. _____ | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| NCR No. _____ | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | |
| | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | |
| Landing Gear | | | | General | | | | | |
| Bending <input type="checkbox"/> | Bend <input type="checkbox"/> | Folio/Program <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | | | | | |
| Centre Not Concentric <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Grain <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Set-up <input type="checkbox"/> | | | | | |
| Cracks <input type="checkbox"/> | Broken/Damage/Defect <input type="checkbox"/> | Hardware <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | | | | | |
| Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Burrs <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Weld <input type="checkbox"/> | | | | | |
| Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Moved <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | | | | | |
| Crushing <input type="checkbox"/> | Countersink <input type="checkbox"/> | Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | | | | | | |
| Heat Treat <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | | | | | | |
| Inspection Strip in Tube <input type="checkbox"/> | Drawing <input type="checkbox"/> | Misread <input type="checkbox"/> | | | | | | | |
| Marks/Chatter <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Off-set <input type="checkbox"/> | | | | | | | |
| Turning Sequence <input type="checkbox"/> | Finish <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | | | | | | | |
| Wave/Twist in Tube <input type="checkbox"/> | Fit/Function <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | | | | | | | |

Work Order ID 124334

September-11-14 12:02:33 PM

124334

Page 2

Item ID: D3639-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 9/10/14 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 9/10/14 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

140

140

Brake NC

NC BRAKE

0.00

DAS
30
9-89

5

14/10/23

Brake NC

Memo

0.00

150

150

QC

QC5- Inspect part completeness to step on W/O

0.00

DAS
38
9-89

Quality Control

Memo

0.00

(5)

06/12/2014

160

160

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

5

14-10-27

JH/DS

DQA: _____ Date: _____



WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--------------------------|----------------------|-----------------------------------|--|---|---------------------------------------|---|---|--------------|--------------|--|--|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | | | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Design | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Transport | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| Bending | Bend | Folio/Program | Outside Dimensions | Pressure/Forced | | | | | | | |
| Centre Not Concentric | BOM/Route | Grain | Over/Under tolerance | Set-up | | | | | | | |
| Cracks | Broken/Damage/Defect | Hardware | Part Incorrect | Temperature/Cure | | | | | | | |
| Crimp/Kink/Ripple/Wave | Burrs | Inspection Incomplete/Unqualified | Part Lost/Missing | Weld | | | | | | | |
| Cuffs | Contamination | Instructions Incomplete/Unclear | Part Moved | Wrong Stock Pulled | | | | | | | |
| Crushing | Countersink | Misaligned/off center | Positioned Wrong | | | | | | | | |
| Heat Treat | Cut Too Short | Mislabeled | Power Loss/Surge | Other | | | | | | | |
| Inspection Strip in Tube | Drawing | Misread | | | | | | | | | |
| Marks/Chatter | Drill Holes | Off-set | | | | | | | | | |
| Turning Sequence | Finish | Out of Calibration | | | | | | | | | |
| Wave/Twist in Tube | Fit/Function | Out of Sequence | | | | | | | | | |

Work Order ID 124334

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124334

Page 3

Item ID: D3639-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 9/10/14 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 9/10/14 **Req'd Qty:** 4.00

4

Customer:

Reference:

| | | | | | | | |
|-------------------|----------------------------|--------------------|-------------------------|--------------------|------------|--------------|--------------|
| Approvals: | Process Plan: _____ | Date: _____ | Tooling: _____ | Date: _____ | Run | Start | *NR1* |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--------------------------------------|------------------------------|----------------|---------------|----------------------|-----------------------|-----------------------|--------------------------|------------------------|
| 170 *170* QC Quality Control | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | DAS 38 9-89 |
| | Memo | 0.00 | | | | | | | |

(5) OCT 27 2014

| | | | | | | | | | |
|--|---|------|--|--|--|--|--|--|-------------------|
| 175 *175* QC Quality Control | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | DAS 38 9-89 |
| | Memo | 0.00 | | | | | | | |

(5) (1) OCT 27 2014
→ P10

| | | | | | | | | | |
|---|---|------|--|--|--|--|--|--|-------------------|
| 180 *180* Packaging Packaging | Identify as per dwg & Stock Location: <i>ST 505</i> | 0.00 | | | | | | | DAS 26 9-89 |
| | Memo | 0.00 | | | | | | | |

(4) OCT 27 2014

DQA:

ShutDate: 14/12/11

QA Closed:

S/ASDate: 14/12/9

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

| Work Order: | Part No. | NCR No. | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---------------|----------------|----------------|----------------------|---------------|----------------------------|---------------------|-----------|-------------|--|--|
| | | | Rework | Scrap | Skid-tube | Crosstube | Water Jet | Engineering | | |
| | | | Use-as-is | Machining | Small Fab | Prod. Eng. Coor. | Quality | | | |
| | | | Suspected Unapproved | Thermoforming | Finishing | Rec/Store/Packaging | Other | | | |
| | | | | Large Fab | Composite | Supplier | | | | |
| <u>124334</u> | <u>D3639-2</u> | <u>14-4423</u> | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|----------|------|-----|---|-------------------|-------------------------------|-------------------|-------------------|-------------------|
| Design | | | | | | | | | |
| Doc/Data | 14-10-27 | 175 | 1 | found 1 pc with corrosion | DAS 16 9-89 | Scrap / destroy no replace | DAS 23 9-89 | DAS 38 9-89 | DAS 16 9-89 |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | | |
|--------------|--------------------------|----------------------|-----------------------------------|----------------------|--------------------|
| Landing Gear | Bending | General | Folio/Program | Outside Dimensions | Pressure/Forced |
| | Centre Not Concentric | Bend | Grain | Over/Under tolerance | Set-up |
| | Cracks | BOM/Route | Hardware | Part Incorrect | Temperature/Cure |
| | Crimp/Kink/Ripple/Wave | Broken/Damage/Defect | Inspection Incomplete/Unqualified | Part Lost/Missing | Weld |
| | Cuffs | Burrs | Instructions Incomplete/Unclear | Part Moved | Wrong Stock Pulled |
| | Crushing | Contamination | Misaligned/off center | Positioned Wrong | |
| | Heat Treat | Countersink | Mislabeled | Power Loss/Surge | |
| | Inspection Strip in Tube | Cut Too Short | Misread | | |
| | Marks/Chatter | Drawing | Off-set | | |
| | Turning Sequence | Drill Holes | Out of Calibration | | |
| | Wave/Twist in Tube | Finish | Out of Sequence | | |
| | | Fit/Function | | | |

Work Order ID 124334

September-11-14 12:02:33 PM

124334

Page 4

Item ID: D3639-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 9/10/14 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 9/10/14 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

190

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

1Q0

QC

Quality Control

0.00

Memo

0.00

14/10/27

AM-10-27

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

| | | |
|---|--|---|
| <p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p> | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
|---|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | |
|--|--|---|--|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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| | | | | |

Picklist Print

September-11-14 12:02:33 PM

Page 1

Work Order ID: 124334

124334
D3639-2

Parent Item: D3639-2

Parent Item Name: Doubler

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:E
remove c'sink DD 10.04.13 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.050 | | Purchased | No | | | 100 | sf | 89.8911 | 0.239 | 2 | | | |

+M800

M2024T3S 050

2024-T3 .050 sheet

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT022 | 89.8911 | |
| (124643) | 37.2911 | |
| m128354 | 42.2 | |
| m128713 | 10.4 | |

2

Be 14/10/19

~~3323~~ 1.666

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

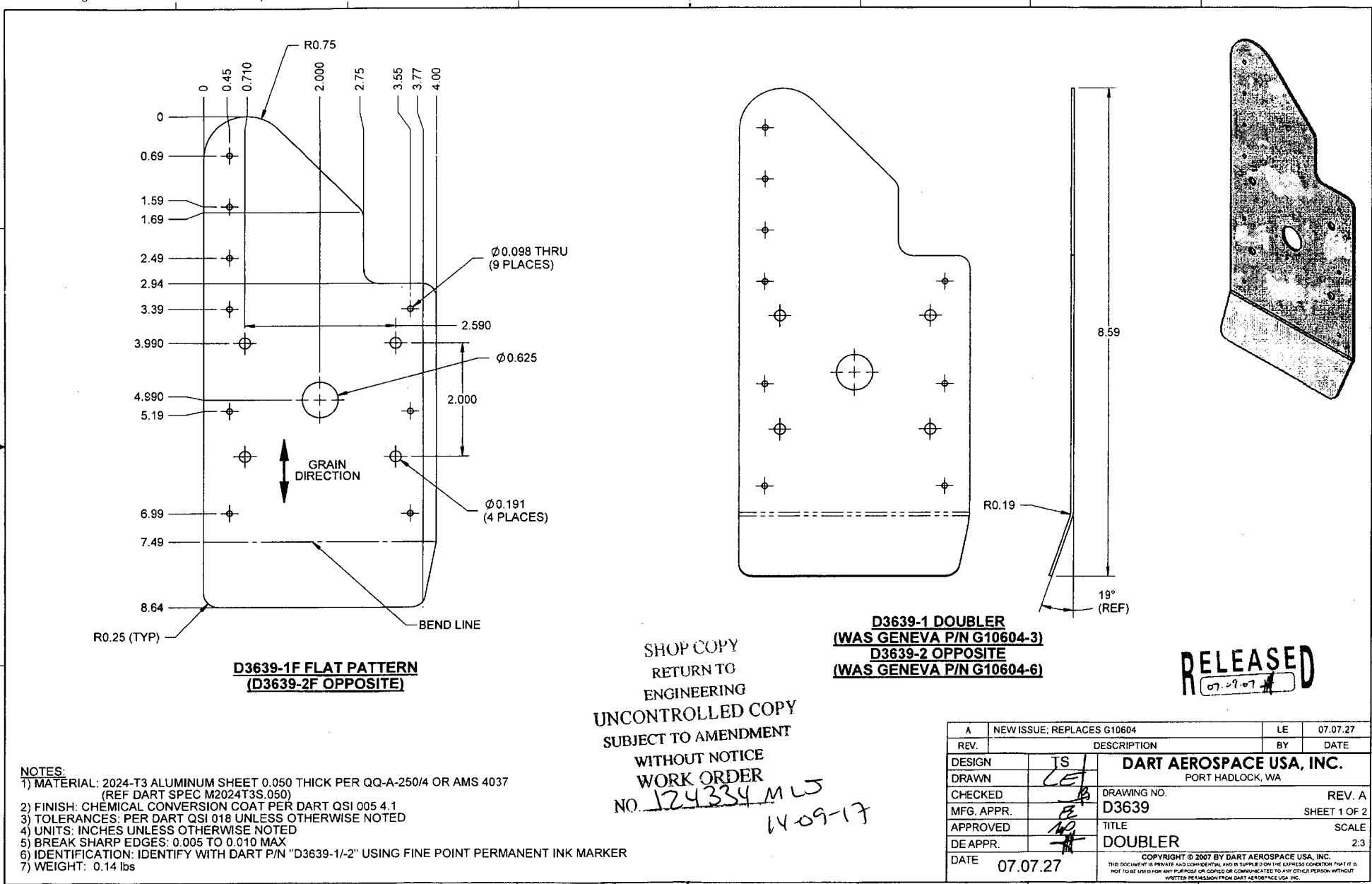
Work Order update only

| | | |
|---|--|---|
| <p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p> | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
|---|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | |
|--|--|---|--|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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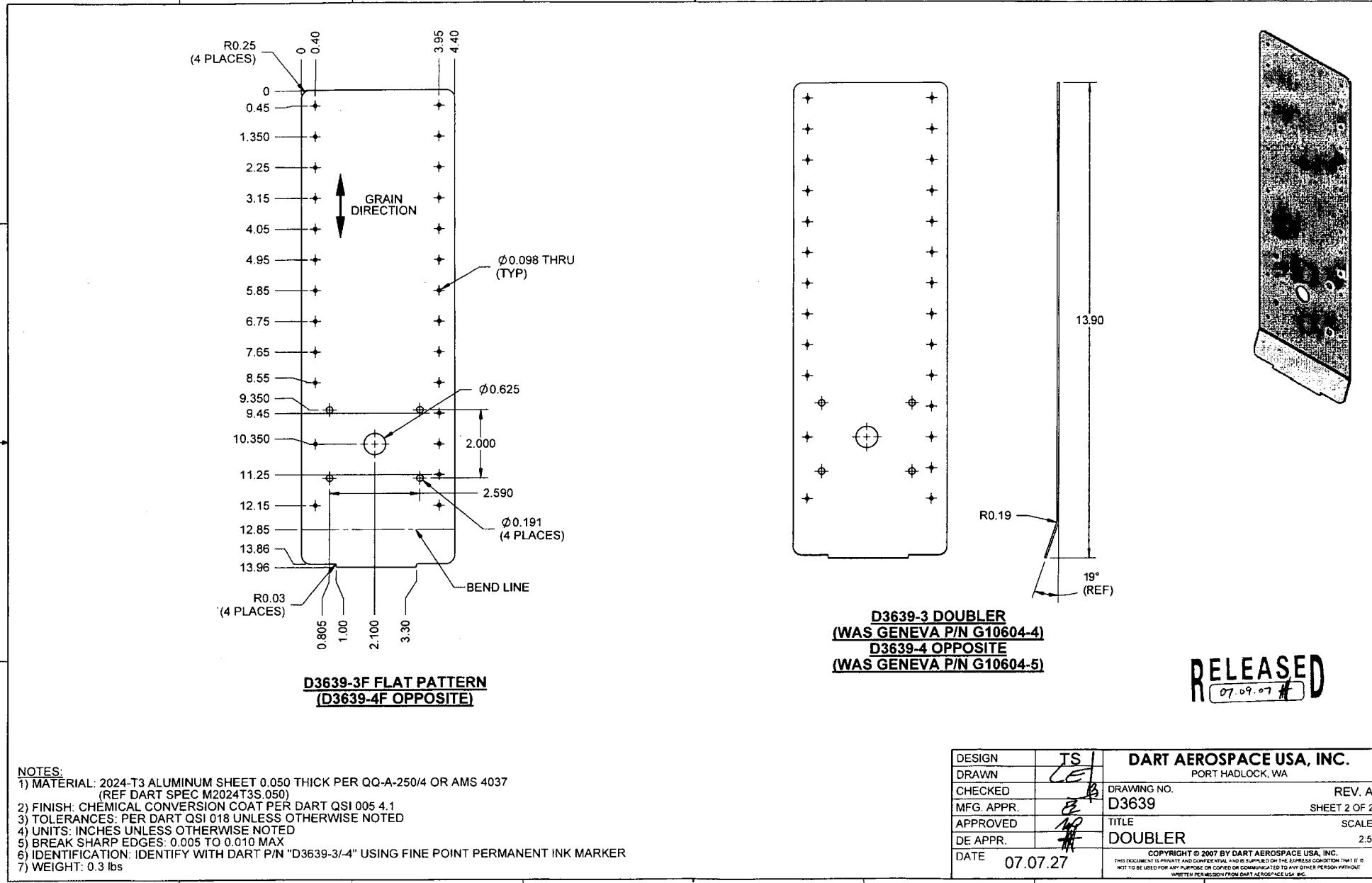
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|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 124334 |
| Description: Doubler | Part Number: | D3639-2 |
| Inspection Dwg: D3639 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.625 | +0.008/-0.001 | .624 | / | | U=SKM-01 | |
| Ø0.191 | +0.005/-0.001 | .191 | / | | T=SKM-06 | |
| Ø0.098 | +0.004/-0.001 | .099 | / | | | |
| .69 | +/-0.030 | .69 | / | | | |
| 1.59 | +/-0.030 | 1.50 | / | | | |
| 2.49 | +/-0.030 | 2.49 | / | | | |
| 3.39 | +/-0.030 | 3.39 | / | | | |
| 3.990 | +/-0.010 | 3.990 | / | | | |
| 4.990 | +/-0.010 | 4.990 | / | | | |
| 5.19 | +/-0.030 | 5.19 | / | | | |
| 6.99 | +/-0.030 | 6.99 | / | | | |
| 8.64 | +/-0.030 | 8.64 | / | | | |
| 0.45 | +/-0.030 | .45 | / | | | |
| 0.710 | +/-0.010 | .710 | / | | | |
| 2.000 | +/-0.010 | 2.000 | / | | | |
| 2.75 | +/-0.030 | 2.75 | / | | | |
| 3.55 | +/-0.030 | 3.55 | / | | | |
| 4.00 | +/-0.030 | 4.00 | / | | | |
| 2.000 | +/-0.010 | 2.000 | / | | | |
| 2.590 | +/-0.010 | 2.590 | / | | | |
| | | | | | DAS | |
| | | | | | 38 | |

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|--------------|----------|-------------|-------------|---------------------|-----|
| Measured by: | De Jez, | Audited by: | 9-89 | Prototype Approval: | N/A |
| Date: | 14/10/19 | Date: | OCT 20 2014 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.10.19 | New Issue | KJ/EC/DD | DA |